

Work Order ID 78719

\*78719\*

Page 1

January-13-12 7:08:32 AM

Item ID: D3140-87 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Doubler  
 Start Date: 12/01/2012 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 26/01/2012 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3140	Rev F

100		0.00							
*100*	SHEAR								12-10-1
Shear	Memo	0.00				6	0		Jan 17 10-1
Shear	Cut as per dwg D3140								

2024 . 032

110		0.00							
*110*	Small Fab								
Small Fab	Memo	0.00				6	0		Jan 17 10-1
Small Fab	1-Scuff surfaces with 80grit sandpaper per QSI 0062-Deburr. No sharp edges								

120	QC5- Inspect part completeness to step on W/O	0.00							
*120*									
QC	Memo	0.00				6			
Quality Control									

Smb / DAS  
 12-10-01 / 16  
 17/10/01

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 78719

\*78719\*

Page 2

January-13-12 7:08:32 AM

Item ID: D3140-87

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 12/01/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1

0.00

\*130\*

HandFinish

Memo

0.00

Hand Finishing

6 76 12-10-03

140 QC3- Inspect Part Finish

0.00

\*140\*

QC

Memo

0.00

Quality Control

6X 4 MZ 12/10/03

150 Identify as per dwg &amp; Stock Location: 205

0.00

\*150\*

Packaging

Memo

0.00

Packaging

(60) 12/10/03

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\*78719\*

Page 3

January-13-12 7:08:32 AM

Item ID: D3140-87

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Doubler

Start Date: 12/01/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


\*160\*

QC

Memo

0.00

Quality Control

12/10/11 

12.10.11

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**NOTE:** Date & initial all entries

# Picklist Print

January-13-12 7:08:36 AM

Page 1

Work Order ID: 78719

**\*78719\***

Parent Item: D3140-87

**\*D3140-87\***

Parent Item Name: Doubler

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 6.00

Required Qty: 6.00

**Comments:**

IPP A02.04.30New IssueNG  
 IPP Rev B New dwg rev. ccn781 06.04.18 EC  
 IPP rev.C added scuffing NCR 061 EC  
 IPP Rev:B As per ECN #829 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.032

Purchased

No

100

sf

106.7000

2.092

~~13.21263~~

**\*M2024T3S 032\***

**\*\***

**13.5**

**Jm 12-10-11**

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT022

106.7

118243

30.7

118523

76

**123096**

**123096**

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**NOTE:** Date & initial all entries





DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED Jsh	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

SHEET 1 OF 7

REFERENCE

REVISION

UNCOMPLETED

SUBJECT

NO.

38719 M.C.J.  
12/01/13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED  
06.11.13 [Signature]

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND  
ALODINE PER DART QSI 005 4.1

F

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61+84

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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[illegible]

RELEASED

06.11.13

Technical drawing of a ship's hull section, showing internal structure and repair details. The drawing includes a side view of the hull and a cross-section labeled SECTION A-A. The cross-section shows the outer shell, inner shell, and various internal components and repairs.

**SECTION A-A**

Labels for SECTION A-A:

- D3140-61 (REF)
- TAPER A/R AS SHOWN
- E761/7781 3 PLY THRU OUT OUTER SHELL
- FILL IN GAPS & BOND PADS MA560 FOAM (A/R)
- ALL OUTER RADII PER TOOL # B30-23000-01T/-02T
- D3140-63 (REF)
- R0.50
- D3140-57 (REF)
- D3140-59 (REF)

**RELEASED**

06 1117 #

**SECTION B-B**

Labels for SECTION B-B:

- D3140-59
- D3140-301 (USE D3140-303 ON -06)
- D3140-57 (REF)
- TAPER A/R AS SHOWN PER TOOL # B30-23000-57T (2 PLACES)
- 1.00 REF
- 1.00 REF
- D3140-61 (REF)
- D3140-63 (REF)
- E761/7781 2 PLY THRU OUT INNER SHELL
- R0.50
- D3140-59 (REF)
- FILL IN GAPS & BOND PADS MA560 FOAM (A/R)
- D3140-57 (3 PLACES)
- ALL OUTER RADII PER TOOL # B30-23000-01T/-02T
- E761/7781 3 PLY THRU OUT OUTER SHELL

**D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)**  
**D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)**  
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

Three triangles are shown, labeled 1, 2, and 3 from left to right. Each triangle is an isosceles triangle with its base horizontal. The triangles are arranged in a row, with their bases touching.

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DESIGN
--------

1

DRAWN BY

**DART**

**DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

	DRAWING NO.
--	-------------

REV. 11-1-77

DATE \_\_\_\_\_

TITLE
-------

SCALE

06.10.06

DOOR

NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

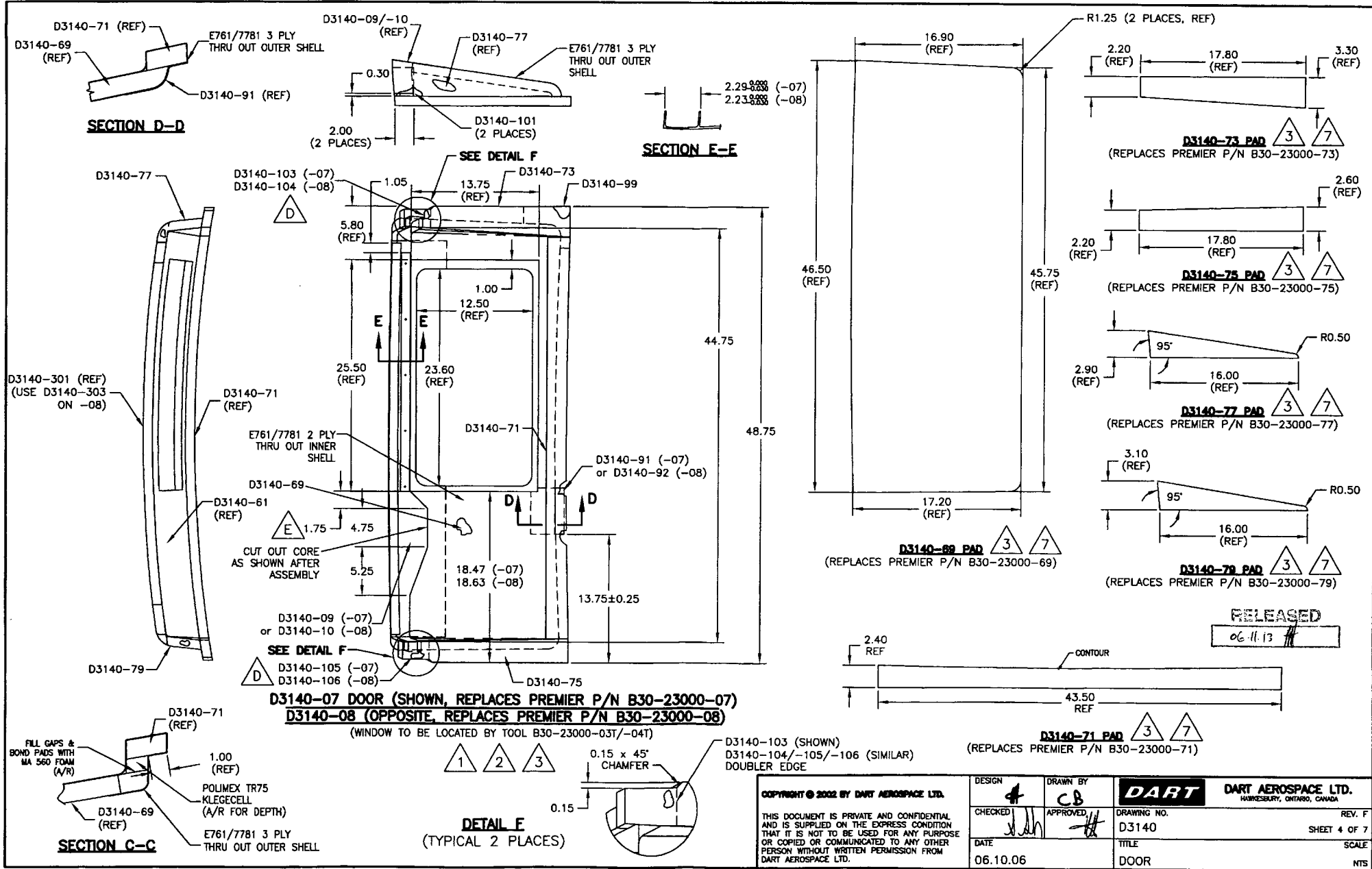
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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				D3140	SHEET 4 OF 7
				TITLE	SCALE
				DOOR	NTS

W/O:		WORK ORDER CHANGES					
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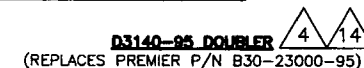
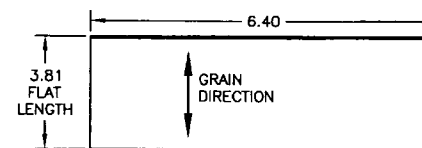
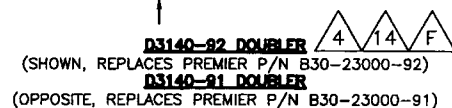
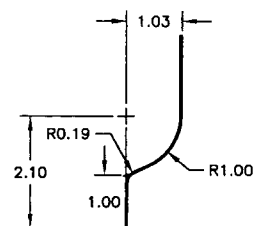
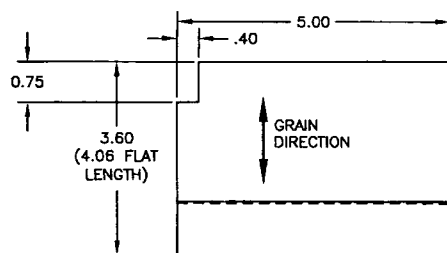
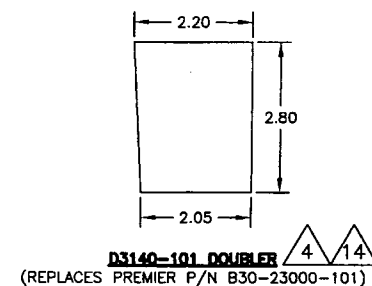
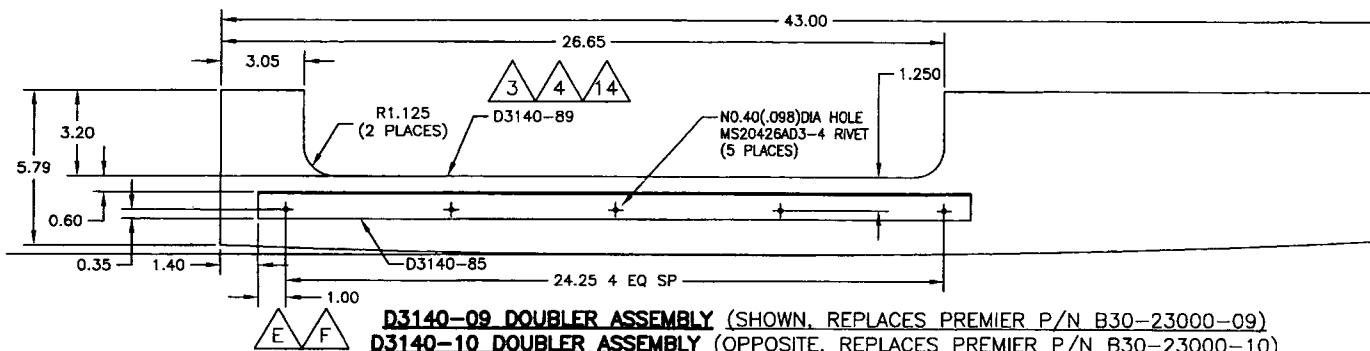
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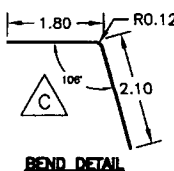
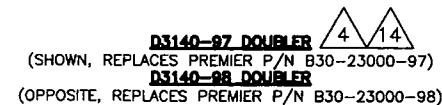
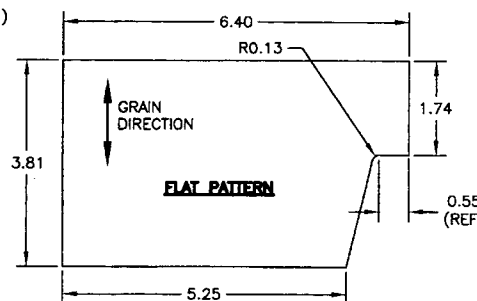
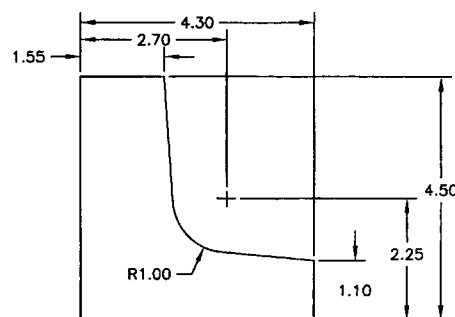
NOTE: Date & initial all entries



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RELEASED  
 06.11.13



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		DATE	06.10.06			D3140	SHEET 5 OF 7
						TITLE	SCALE
						DOOR	NTS

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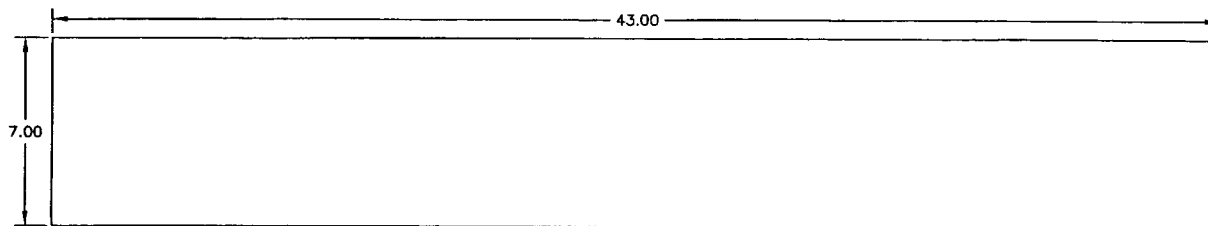
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

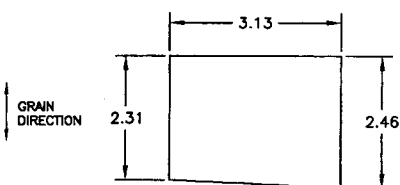
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

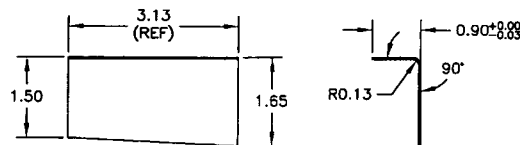
78719



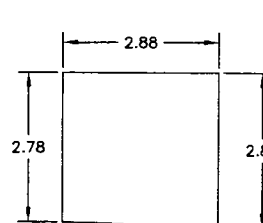
**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)



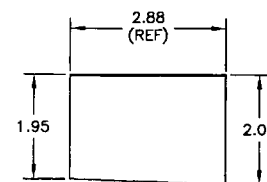
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)



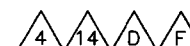
**D3140-105 DOUBLER**  
(REF)  
D3140-106 OPPOSITE



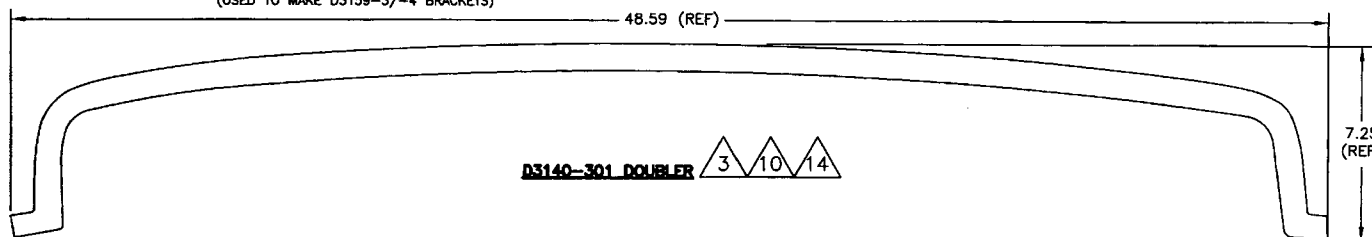
**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)



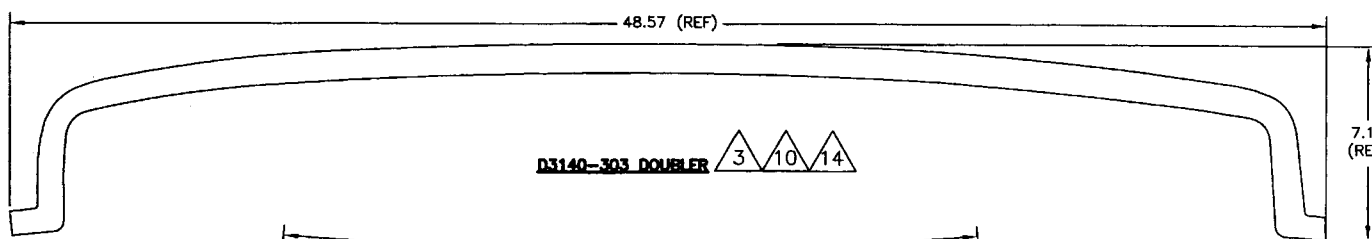
**D3140-104 DOUBLER**  
D3140-103 OPPOSITE



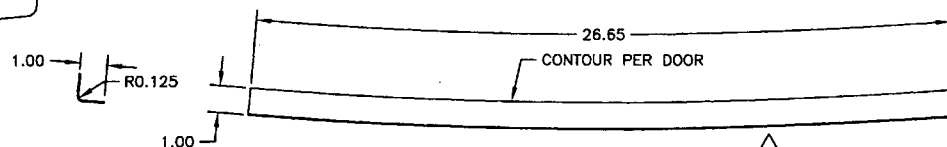
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**



**D3140-303 DOUBLER**



**D3140-85 ANGLE**   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

06.11.13

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DESIGN		DRAWN BY	CB	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO.	REV. F
DATE	06.10.06	TITLE	DOOR	SHEET 6 OF 7	SCALE
				NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

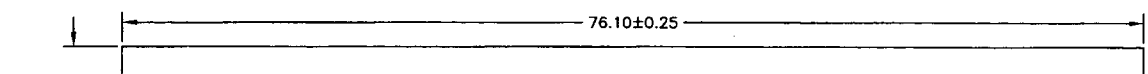
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

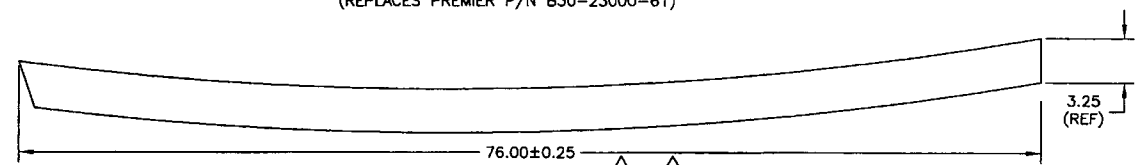
NOTE: Date & initial all entries

78719



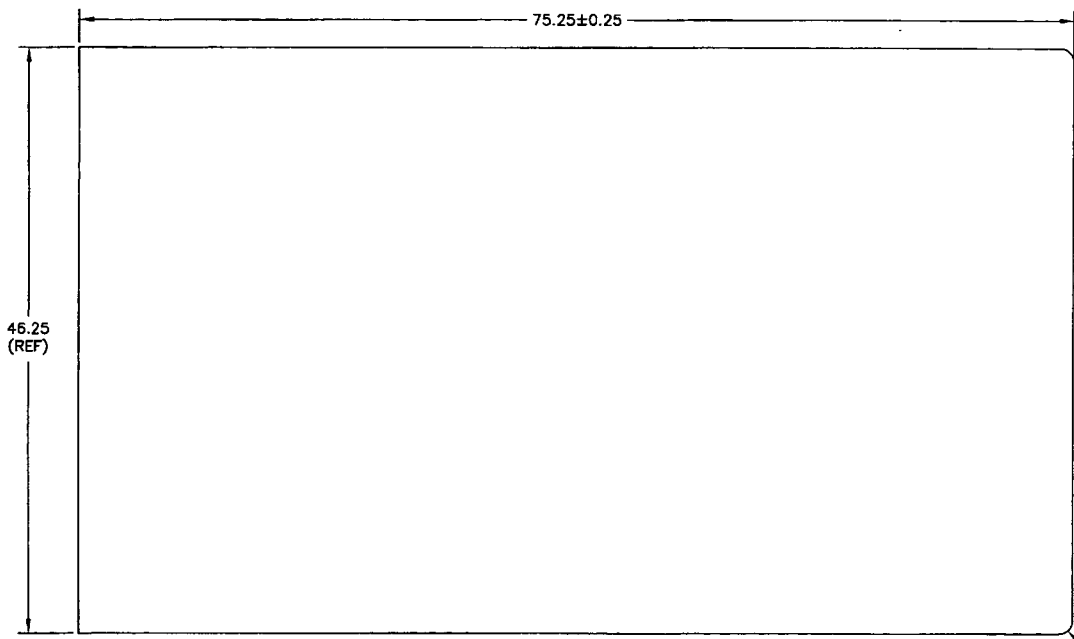
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(REF)

**D3140-61 PAD**  $\triangle 3 \triangle 7$   
(REPLACES PREMIER P/N B30-23000-61)



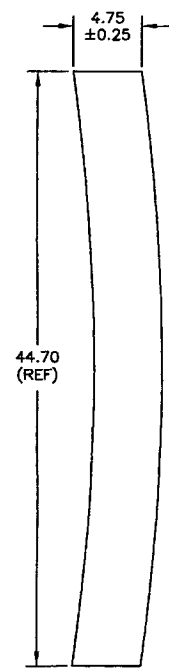
**D3140-63 PAD**  $\triangle 3 \triangle 7$   
(REPLACES PREMIER P/N B30-23000-63)

3.25  
(REF)



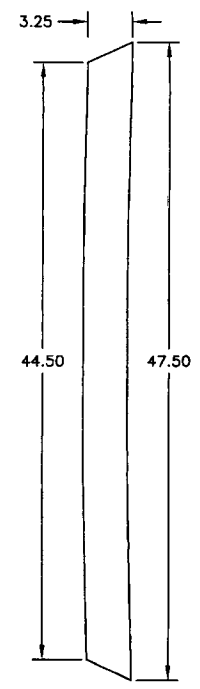
75.25 ± 0.25

46.25  
(REF)



**D3140-57 PAD**  
(REPLACES PREMIER P/N B30-23000-57)

$\triangle 3 \triangle 7$



**D3140-241 DOUBLER**  $\triangle 5 \triangle 14$   
(REPLACES PREMIER P/N B30-23000-241)

R1.00  
(2 PLACES, REF)

**D3140-59 PAD**  $\triangle 7$   
(REPLACES PREMIER P/N B30-23000-59)

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		DATE 06.10.06	TITLE DOOR	SCALE NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

